

Work Order ID: 66703

Thursday, February 24, 2011 10:03:08 AM

Page 1

Item ID: D4055-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Tank Assembly

Start Date: 2/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 11-02-24 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

A

Pto →

100

Weld per dwg A/R Aluminum rod Batch: *M108436* 0.00

M115928

Large Fab

Memo

0.00

Large Fab

1- weld D4023-1 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5- Weld D4055-7 fwd end

10.03.23 *1/0*

W/O: 66703		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/09	#100	Perm. change ADD Reenting numbers to Pch lists.	<i>[Signature]</i>	11.03.31	1	N/A	<i>[Signature]</i> 11/03/09

Part No: D4055-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

1 0 BE 11/03/23

121

Weld per dwg A/R Aluminum rod Batch: M105928 0.00

M114703

Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

1211.03.25

1 0

122

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

1 0 BE 11/03/29

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

123

QC5- Inspect part completeness to step on W/O

0.00

8/10/29

QC

Memo

0.00

Quality Control

Pressure Test as per dwg D4055

Why? Pressure tested to 4.0 psi
for 30 min.

[Signature]

11/03/27

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

1 BL 11-3-29

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 11/3/29



W/O:		WORK ORDER CHANGES					
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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

N/A 11/03/29

170



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

0.00

Mask prior to powdercoat
Start Time: *3:45*
Oven Temperature: *320°*
Finish Time: *4:15*

1 BK 11-3-29

180



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

1 d 11/03/30

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

185



SprayPaint

Memo

M113984
M116444

0.00

0.00

Spray Painting

✓ Seal inside of tank using Sloshing Sealer as per dwg

1 d M 11/03/30

190



Small Fab

Memo

Assemble as per dwg

0.00

0.00

Small Fab

E 54/03/31 @

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/11/03/31

(H)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Packaging

0.00

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

C4113/31 (i)

11/3/31

MF
11-03-31

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, February 24, 2011 10:03:02 AM

Page 1

Work Order ID: 66703

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No				Each	3.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				3					
					55400			3					
D3997-5 Placard		Manufactured	No				Each	11.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				11					
					55402			1					
					65436			10					
D3997-11 Placard		Manufactured	No				Each	12.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				12					
					55407			2					
					65124			10					

1
EP 11/03/30

2
EP 11/03/30

1
EP 11/03/30

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 66703

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-17

Manufactured No

Each

12.0000



Placard



1
EP 11/03/30

Location

Loc Qty

Loc Code

ST108

12

55410

3

65125

9

D3997-29

Manufactured No

Each

12.0000



Placard



1
EP 11/03/30

Location

Loc Qty

Loc Code

ST108

12

55416

3

65126

9

D3997-43

Manufactured No

Each

12.0000



Placard



1
EP 11/03/30

Location

Loc Qty

Loc Code

ST108

12

55422

2

65127

10

D3999-7

Manufactured No

Each

6.0000



Corner



1
EP 11.03.18

Location

Loc Qty

Loc Code

ENG

4

55645

4

ST110

2

59478

2

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Work Order ID: 66703

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3999-9



Angle

Manufactured No

Each 5.0000



1

11.03.18

Location

Loc Qty

Loc Code

ENG

5

55646

5

Each 5.0000



1

11.03.18

D3999-10



Earth Tab

Manufactured No

Location

Loc Qty

Loc Code

ENG

5

55863

5

Each 4.0000



1

11.03.18

D3999-041



Baffle Assembly, Aft

Manufactured No

Location

Loc Qty

Loc Code

ST137

4

65437

4

Each 4.0000



1

11.03.18

D3999-043



Baffle Assembly, Fwd

Manufactured No

Location

Loc Qty

Loc Code

ST137

4

65439

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Work Order ID: 66703

Parent Item: D4055-041

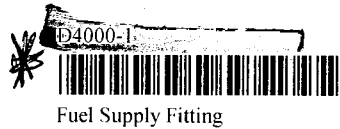
Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00



Manufactured No

Each

4.0000

1

11.03.18

Location

Loc Qty

Loc Code

ENG

1

55867

1

ST

3

59698

3



Manufactured No

Each

2.0000

1

11.03.22

Location

Loc Qty

Loc Code

ENG

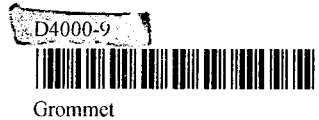
2

55869

1

59699

1



Manufactured No

Each

11.0000

3

11.03.18

Location

Loc Qty

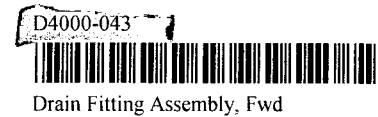
Loc Code

ST105

11

65109

11



Manufactured No

Each

1.0000

1

11.03.18

Location

Loc Qty

Loc Code

WA

1

65036

1

Thursday, February 24, 2011 10:03:03 AM

Shop Packet Print

Page 4

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Page 5

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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D4000-045



Fuel Pickup Fitting Assembly

Manufactured No

Each

3.0000

1



11.03.18

Location

Loc Qty

Loc Code

WA

861063

3

65194

3

Each

1.0000

1



11.03.18

D4000-041



Drain Fitting Assembly, Aft

Manufactured No

Location

Loc Qty

Loc Code

WA

865440

1

65038

1

Each

2.0000

1



11.03.18

D4001-1



Fitting

Manufactured No

Location

Loc Qty

Loc Code

ENG

2

59487

2

Each

8.0000

1



11.03.18

D4008-11



Hinge Half

Manufactured No

Location

Loc Qty

Loc Code

N/A

1

59490

1

WA

7

65445

7

1

Thursday, February 24, 2011 10:03:04 AM

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Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D4008-041
Fuel Filler Splash Guard Assembly

Manufactured No

Each 3.0000

Location

Loc Qty

Loc Code

ST112

3

55875

1

59517

2

Each 0.0000

D4023-1
Cap and Flange

Manufactured No

Each 0.0000

D4025-1
Fuel Quantity Sender

Manufactured No

Each 1.0000

D4055-111
Tank Front and Bottom

Manufactured No

Location

Loc Qty

Loc Code

WA

[365447]

1

63944

1

Each 2.0000

D4055-9
Tank Back

Manufactured No

Location

Loc Qty

Loc Code

WA

[365451]

2

63948

2

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Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00



Manufactured No

Each 4.0000



1

11.03.18

Location

Loc Qty

Loc Code

ST141a

2

65450

2

WA

2

64032

2

Each

4.0000



1

11.03.18



Manufactured No

Location

Loc Qty

Loc Code

ST119

2

65449

2

WA

2

63946

2

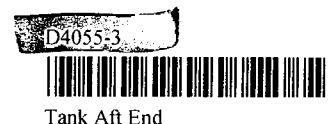
Each

4.0000



1

11.03.18



Manufactured No

Location

Loc Qty

Loc Code

ST141a

3

65448

3

WA

1

64030

1

Each

5.0000



1

11.03.18



Manufactured No

Location

Loc Qty

Loc Code

ST139A

5

64031

2

65446

3

1

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Parent Item Name: Fuel Tank Assembly

Start Date: 2/28/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D4057-1

Manufactured No

Each

27.0000

3



Retaining Ring



11.03.18

Location

Loc Qty

Loc Code

ST124

27

55826

27

3

AN3H5A

Purchased

No

Each

30.0000

5



Bolt



5/11/03/30

Location

Loc Qty

Loc Code

ST350

30

114941

10

116704

20

5

NAS1149D0363J

Purchased

No

Each

2,577.000

5



Washer



5/11/03/30

Location

Loc Qty

Loc Code

ST298

2577

116007

1

116583

2576

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

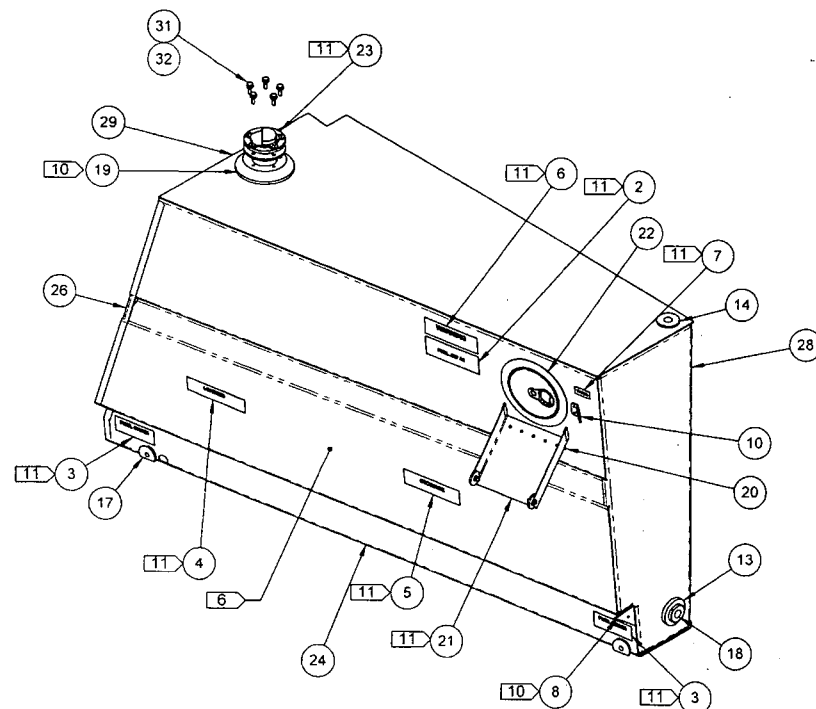
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3999-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-1	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-11	TANK FRONT AND BOTTOM
25	1	D4055-9	TANK BACK
26	1	D4055-7	TANK FORWARD END
27	1	D4055-5	TANK UPPER CUT OUT
28	1	D4055-3	TANK AFT END
29	1	D4055-1	TANK TOP
30	3	D4057-1	RETAINING RING
31	5	AN3H5A	BOLT
32	5	NAS1149D0363J	WASHER



D4055-041 AUX TANK

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT

A	NEW ISSUE	10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.04.16	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4055** REV. A
SHEET 1 OF 15

TITLE **TANK** SCALE NTS

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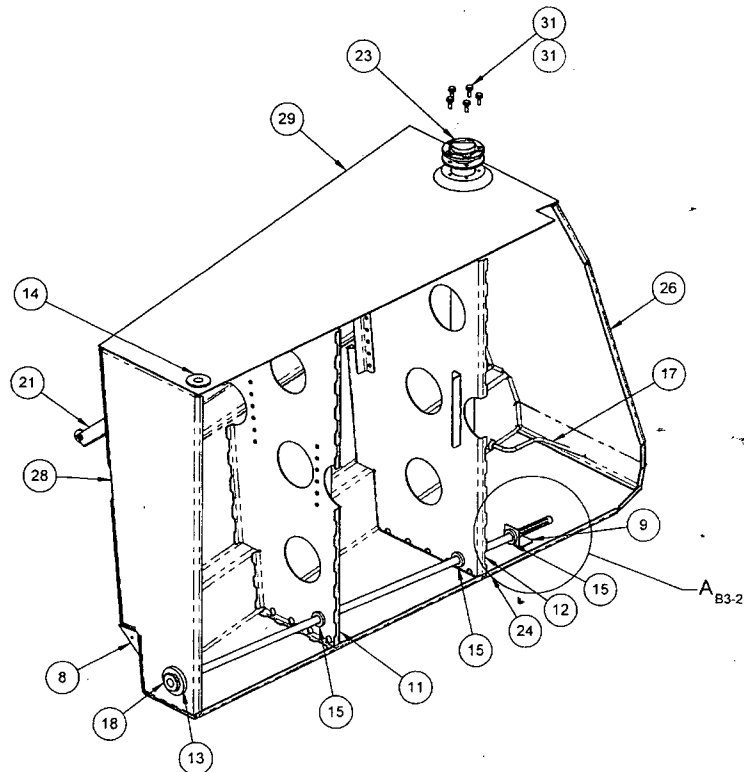
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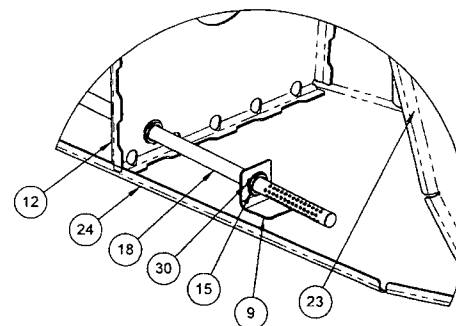
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 AUX TANK
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A B3-2
ROTATED FOR CLARITY
SCALE: 2X

RELEASED
2010-05-05
JW

#66703

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. A
MFG. APPR.			SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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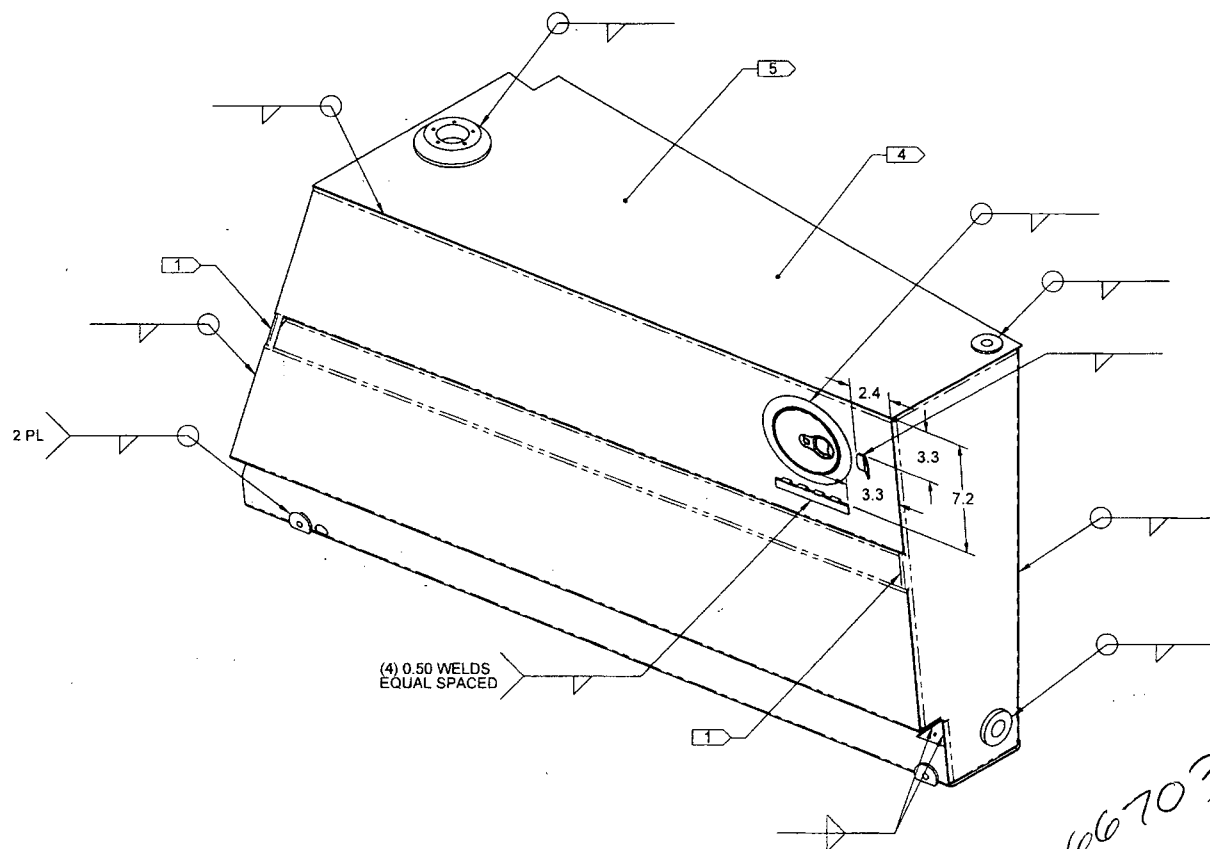
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 AUX TANK
WELDING DETAIL

*66703

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2010-05-05
MD

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED:
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH FUEL TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH) SLOSHING SEALER. ENSURE FILTERS, FITTINGS AND SENDER UNITS ARE REMOVED AFTER WELDING
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

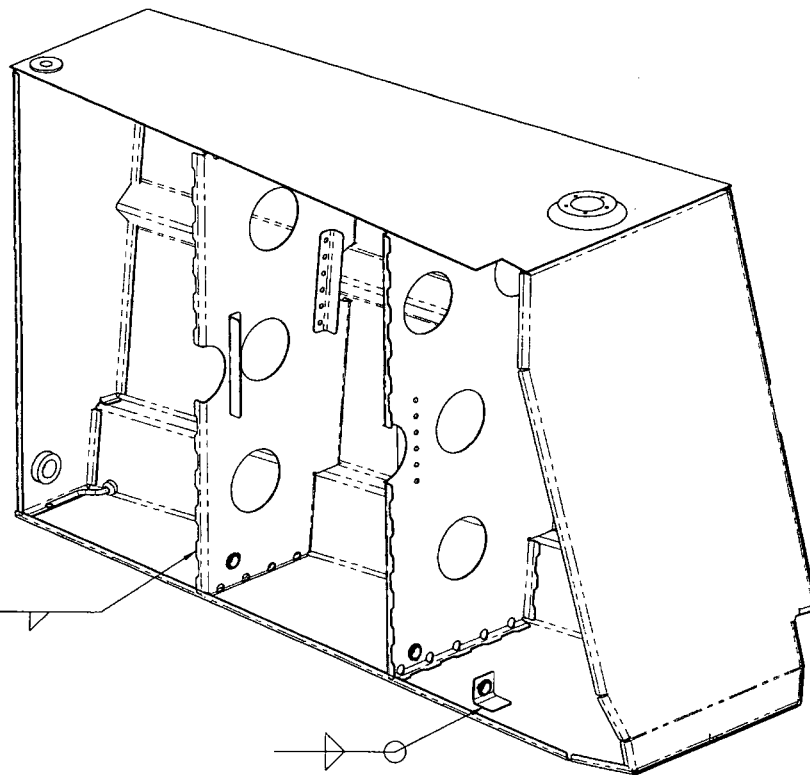
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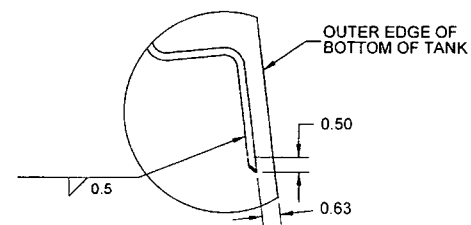
B

A

WELD ALL TABS



D4055-041 AUX TANK
WELDING DETAIL



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

#66703

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2010-05-05
MP

DESIGN	451	DART AEROSPACE LTD	
DRAWN	451	HAWKESBURY, ONTARIO, CANADA	
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A

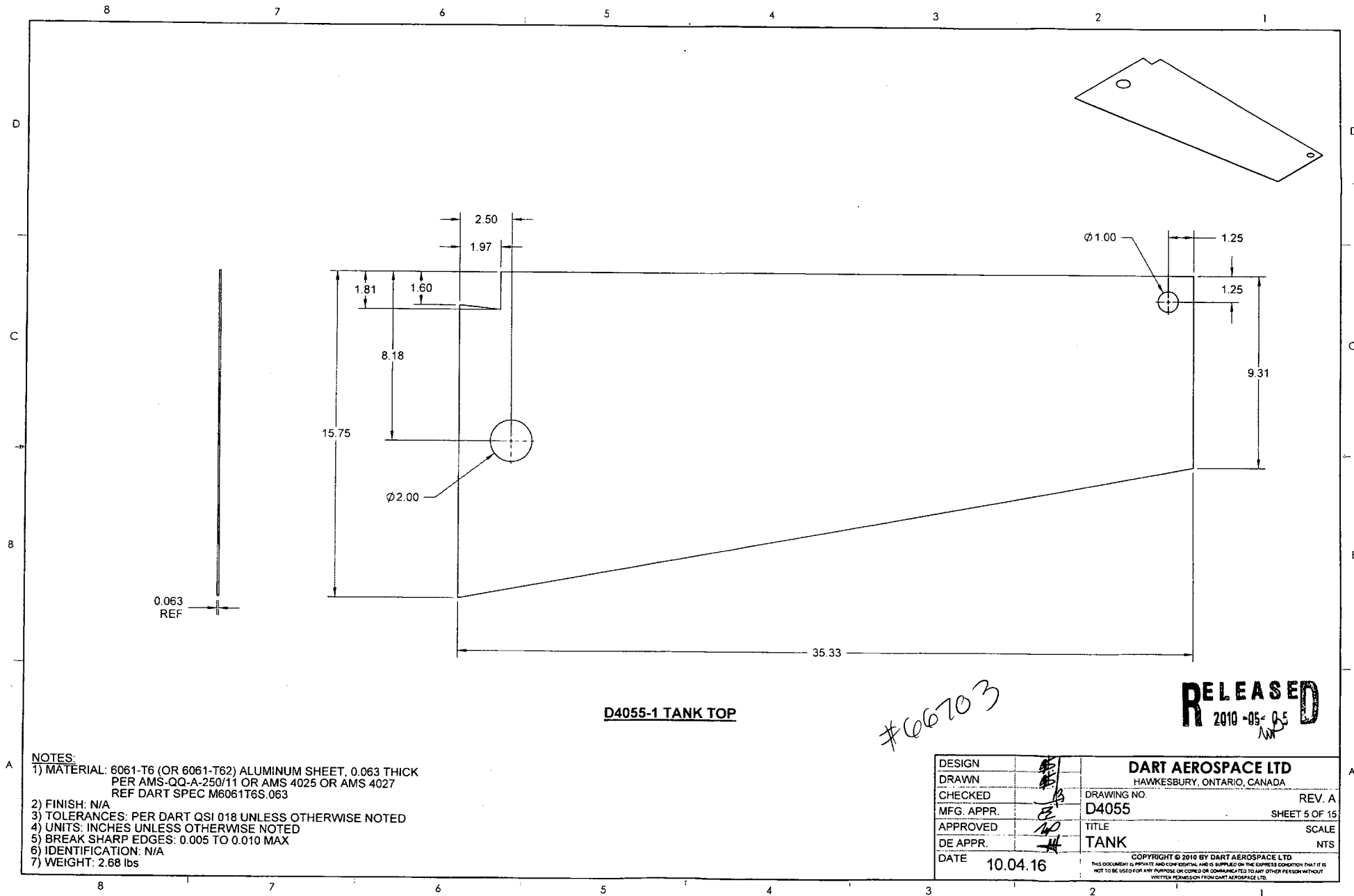
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NOTE: Date & initial all entries



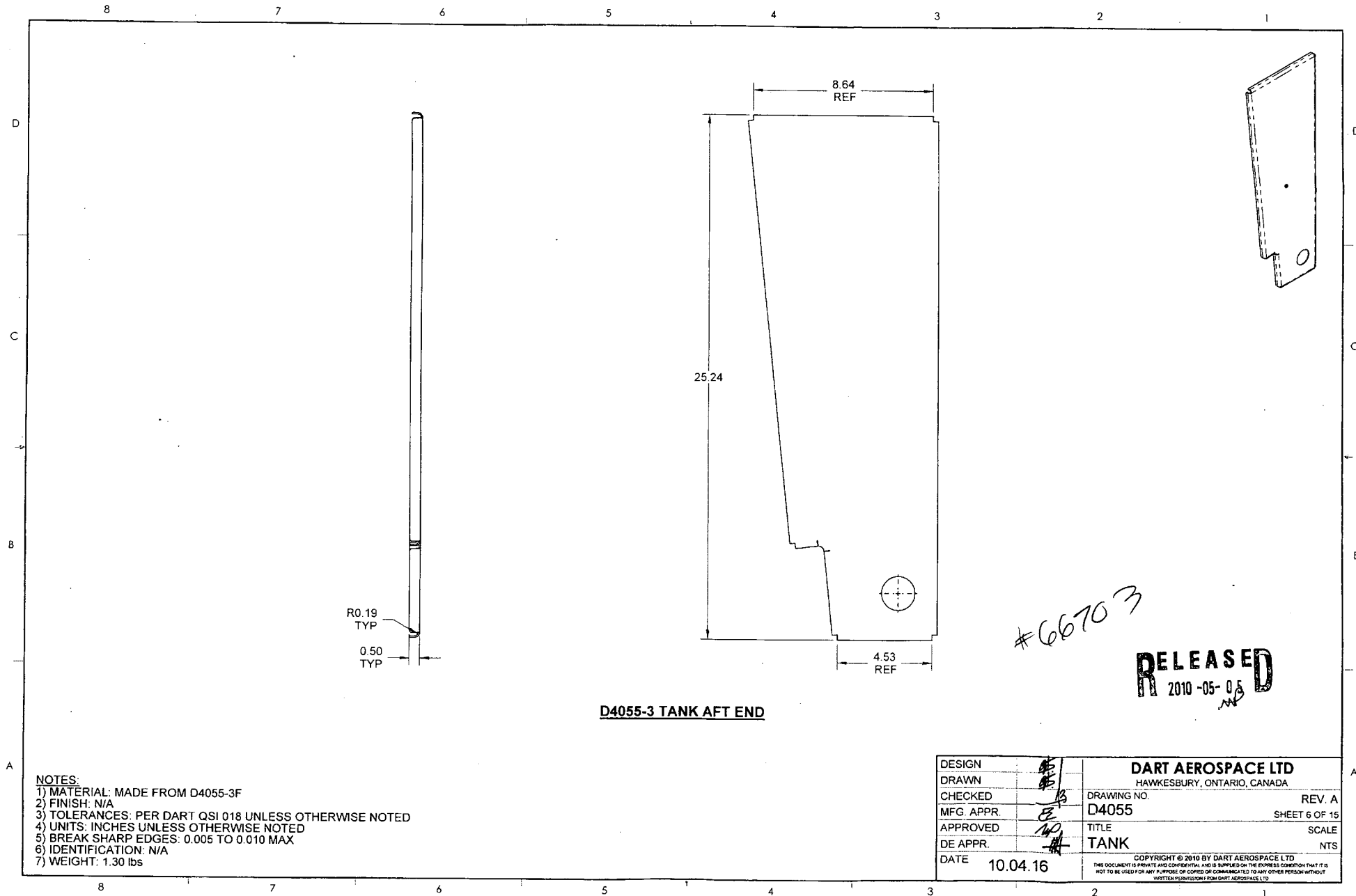
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NOTE: Date & initial all entries



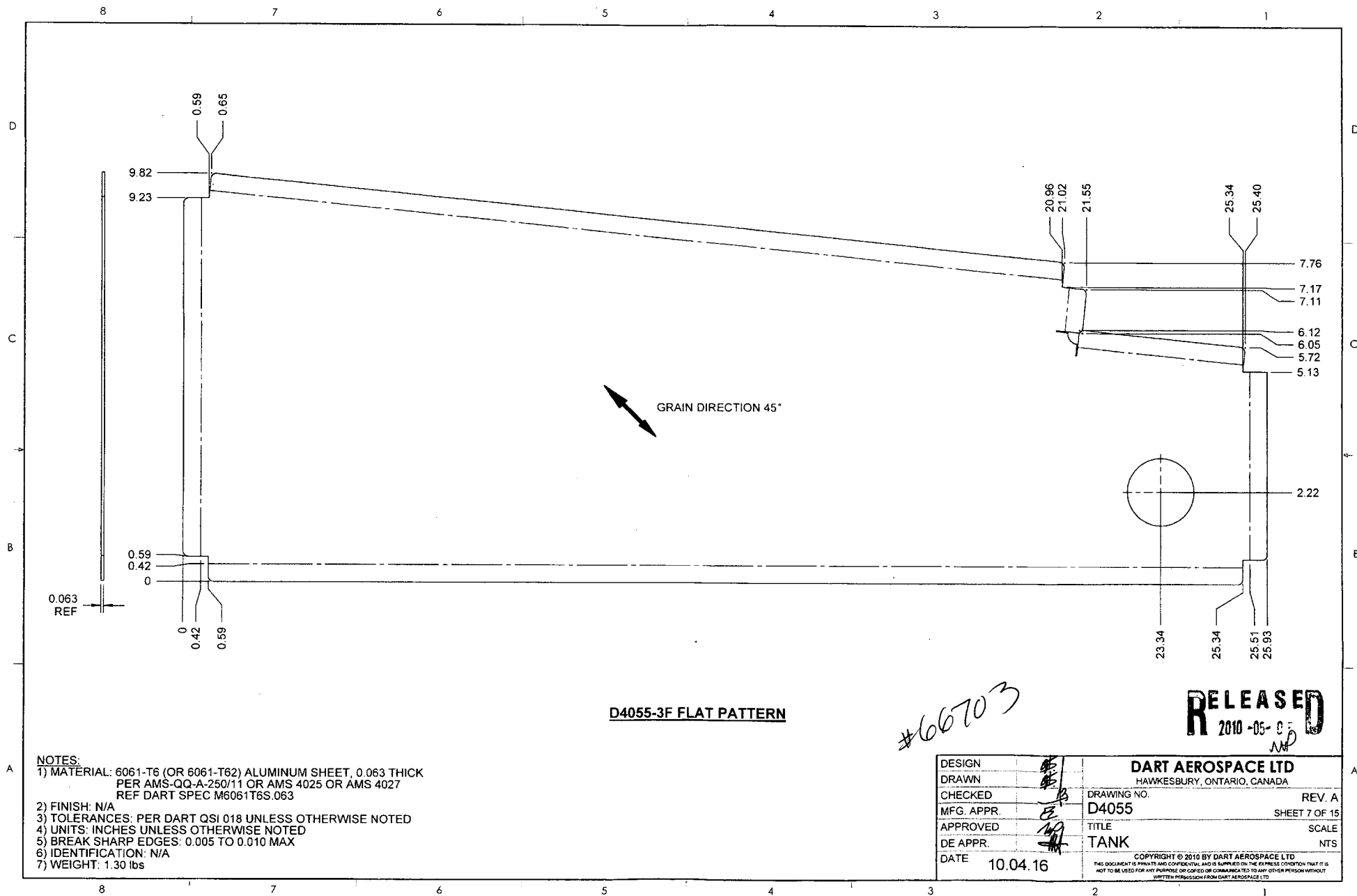
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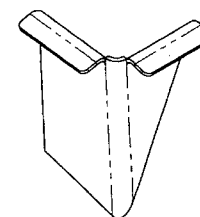
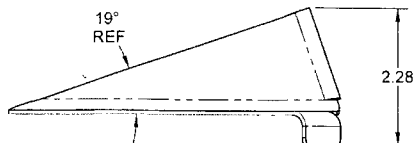
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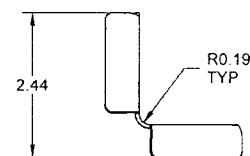
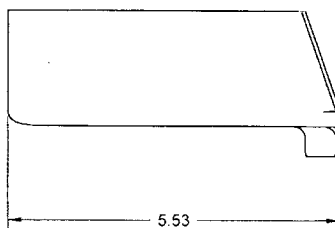
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



C



B

D4055-5 UPPER CUT OUT

A

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

8 7 6 5 4 3 2 1

#66703

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2010-05-05
WR

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 8 OF 15
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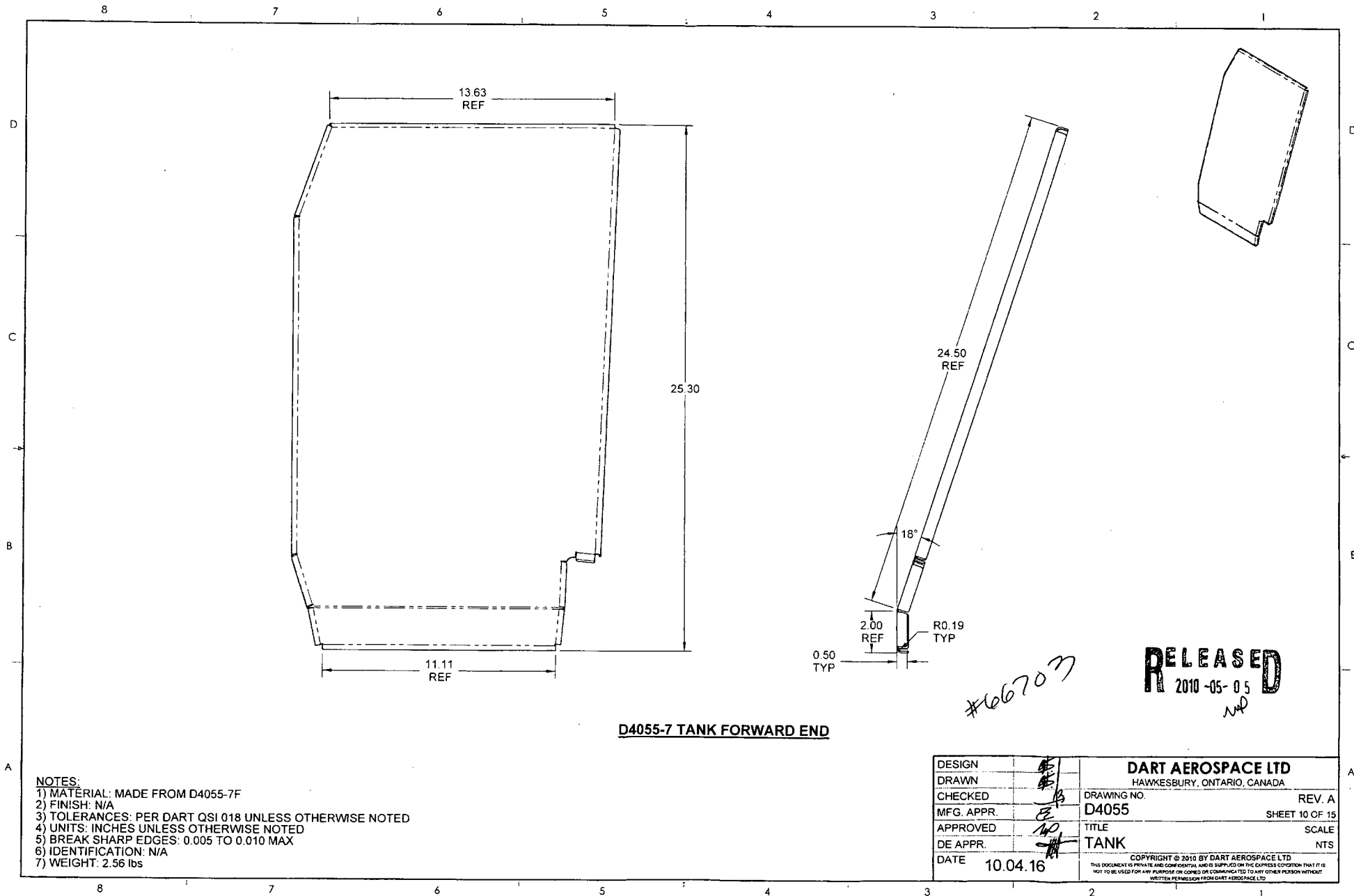
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

D4055-7 TANK FORWARD END

DESIGN		DART AEROSPACE LTD	
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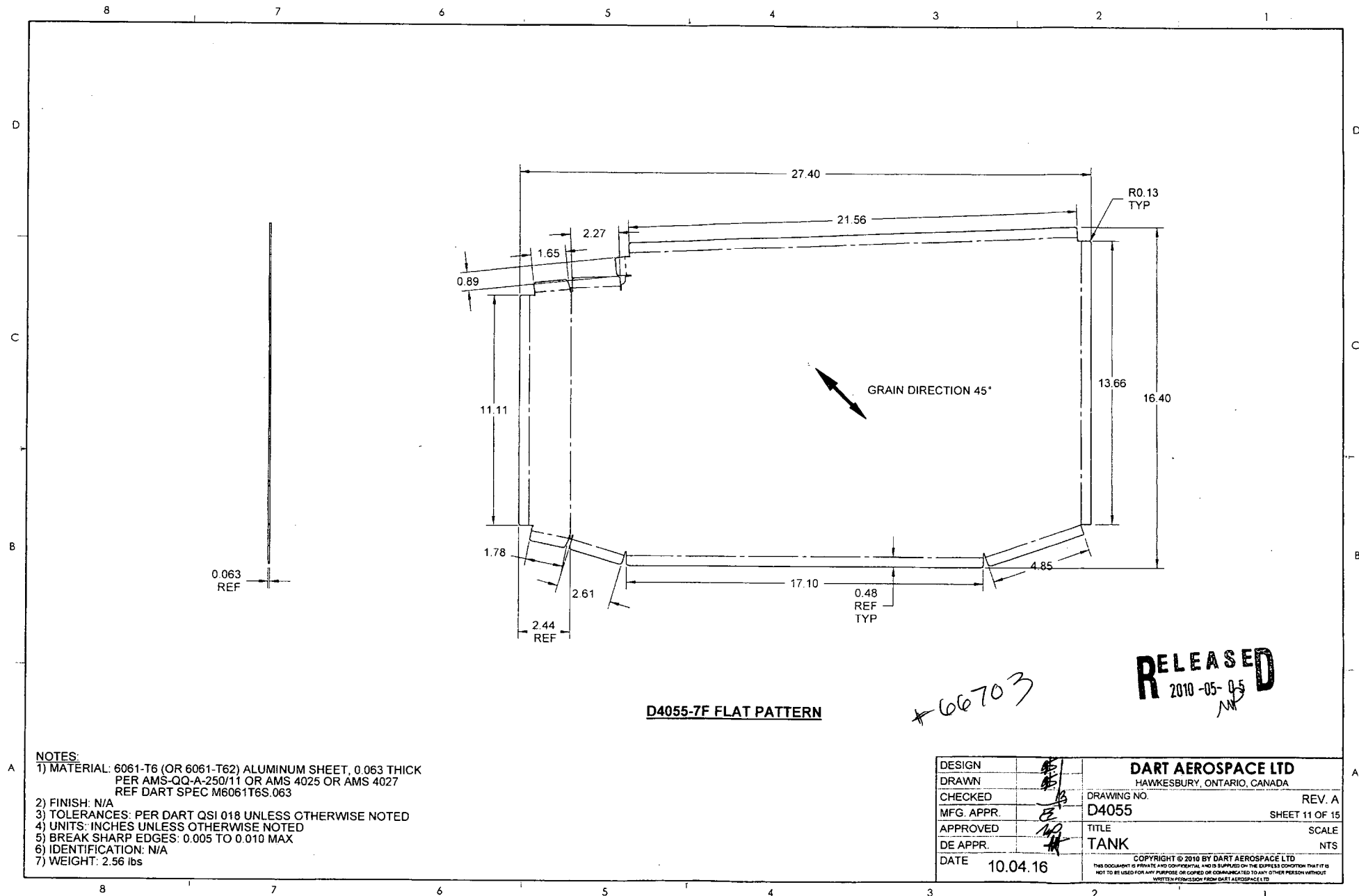
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NOTE: Date & initial all entries



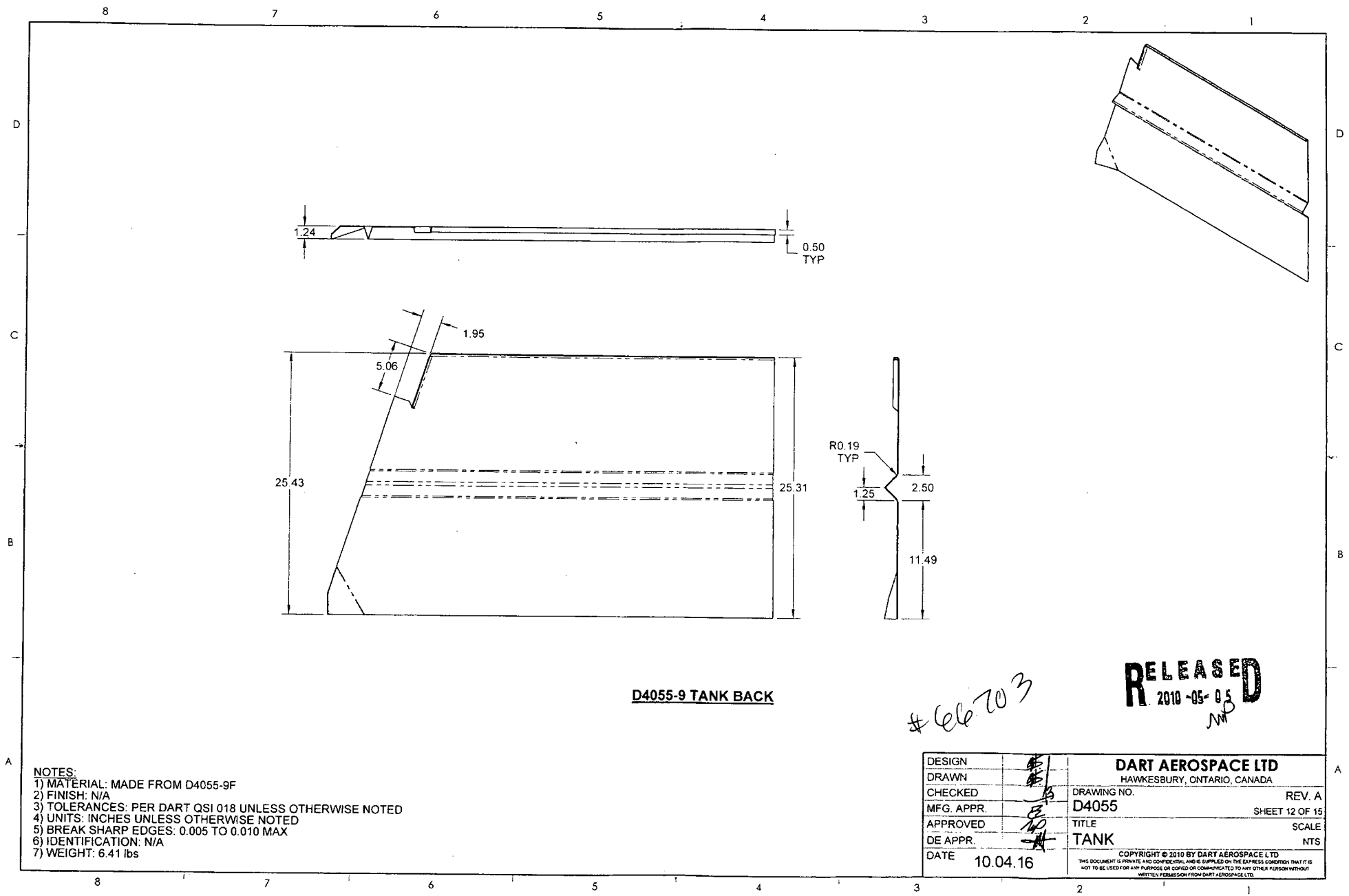
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4055-9 TANK BACK

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs

#66703

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MFG. APPR.		D4055	SHEET 12 OF 15
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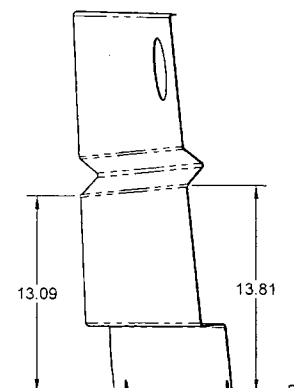
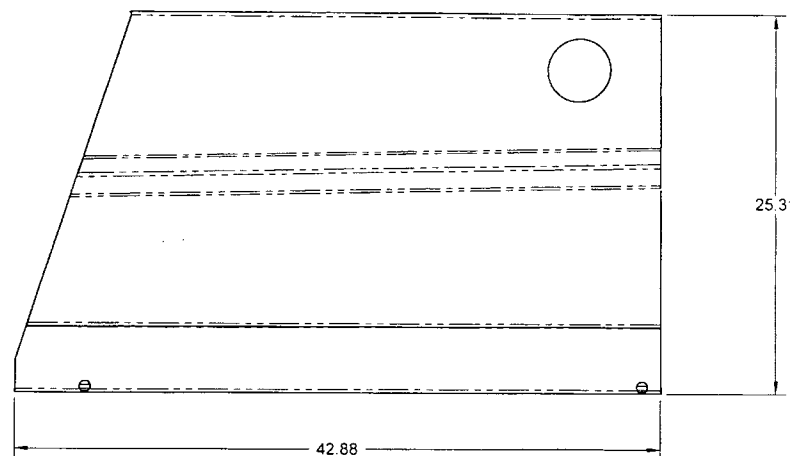
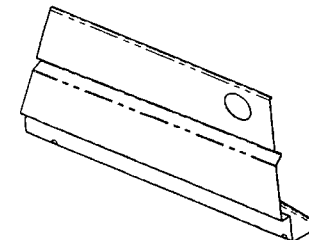
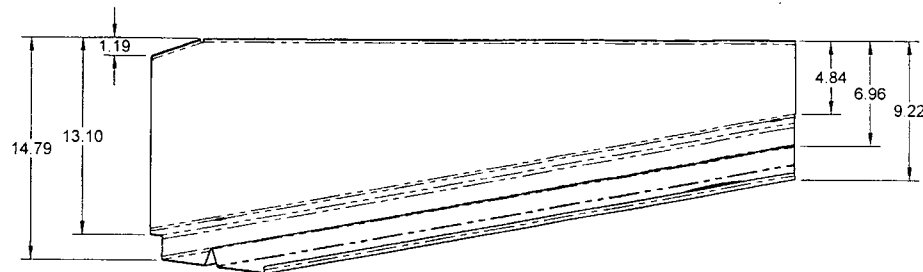
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NOTE: Date & initial all entries



D4055-11 TANK FRONT AND BOTTOM

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4055	SHEET 14 OF 15
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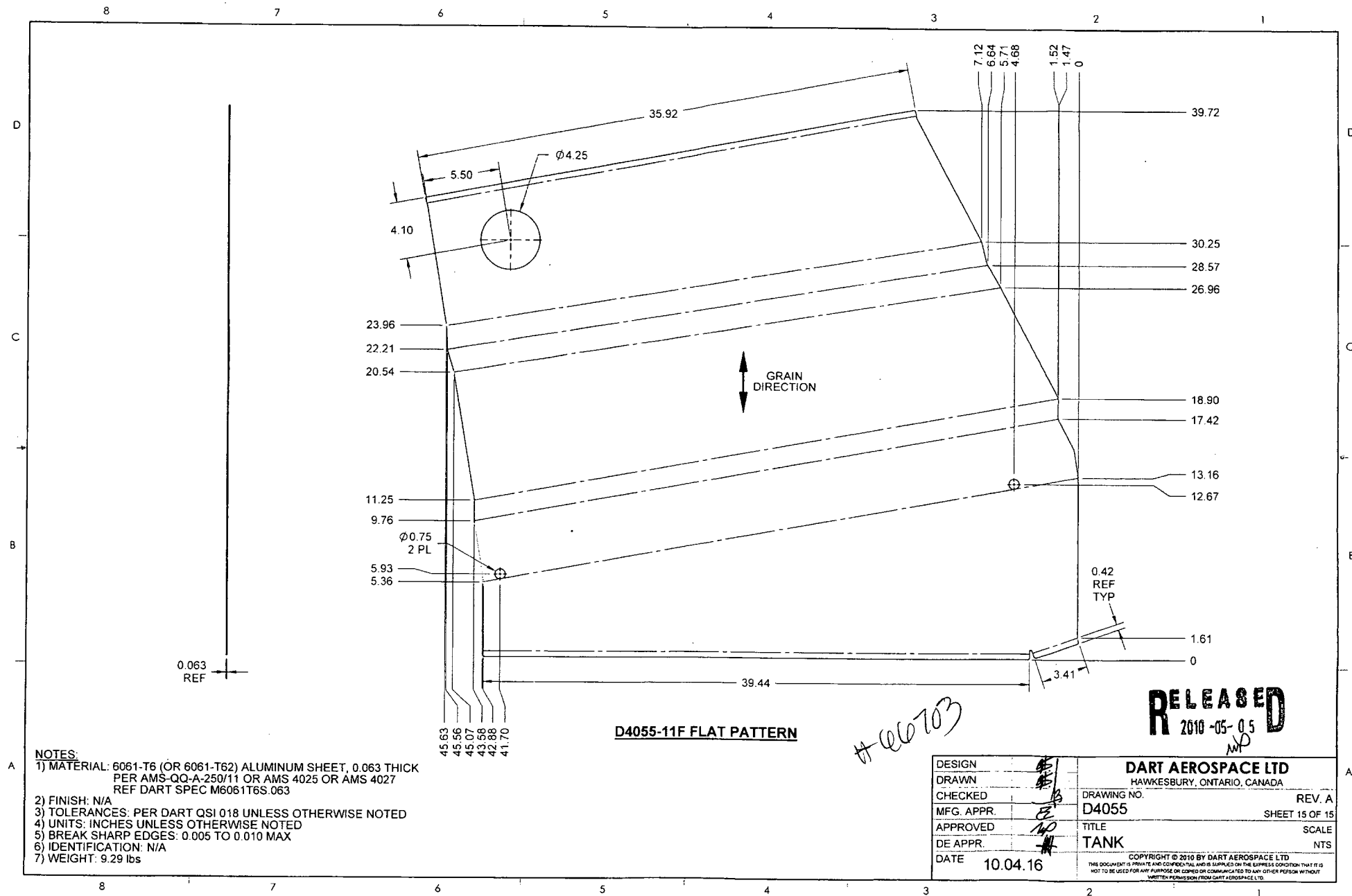
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 15 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries